

Work Order ID 159157

Wednesday, April 05, 2017 9:07:33 AM

159157

Page 1

Item ID: D4732-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Label
Start Date: 4/6/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 4/17/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: DAS 13 9-09 Date: APR 05 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4732	B

100

0.00

100

Purchasing

Purchasing

Memo

0.00

Issue P/O: 35850

E-mail or Ship electronic file and or dwg to vendor

Manufacture as per Dwg and supplied files

Possible supplier: Studio Letrage

Material release note is required.

6APR 05 2017DAS 13 9-09

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.12

6x 2017-4-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				6			DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control									APR 18 2017
130	Identify as per dwg & Stock Location: <u>MFOOS</u>	0.00				6			APR 18 2017 DAS 6 9-89
130									
Packaging	Memo	0.06							
Packaging	***ONE YEAR EXPIRED DATE FROM RECEIVING: MAR 8 2018***								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.60							17/4/20 JG
Quality Control									

DAS
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9-89

M 20/04/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																														
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :				
Misidentified ☐	Past Due ☐																																																																	

Picklist Print

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Work Order ID: 159157

159157

Parent Item: D4732-1

D4732-1

Parent Item Name: Label

Start Date: 4/6/2017

Required Date: 4/17/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.11.08 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4732-1P		Purchased	No			100	Each	0.0000	1	6			
D4732-1P									**				
Label													

6x SP 17-4-17.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

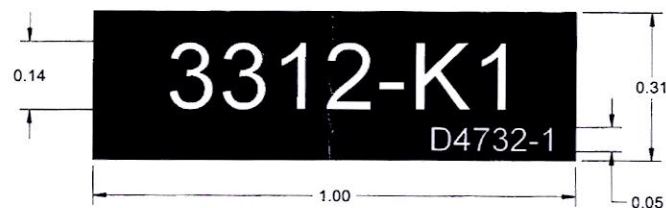
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

APR 05 2017

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W10:159157



D4732-1 LABEL

NOTES:

- 1) MATERIAL: MAKE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
ARIAL FONT WHITE LETTERS ON BLACK ADHESIVE BACK VINYL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
2013 -01- 30

B	ADD D4732-41 (ZN B4-21)	RF	12.11.30	
A	NEW ISSUE	RF	12.07.25	
REV.	DESCRIPTION	BY	DATE	
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED			DRAWING NO.	REV. B
MFG. APPR.			D4732	SHEET 1 OF 2
APPROVED			TITLE	SCALE
DE APPR.			LABELS	NTS
DATE	12.11.30	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35850**

Purchase Order Date 4/5/2017
PO Print Date 4/5/2017

Page Number 4 of 6

Order From :
STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

VC-STU001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613 632 5449

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Total: \$80.00

10	D3997-41P	Placard	4/13/2017	6.00	\$13.33	\$80.00
			Yes	Each		
			4/13/2017			

AS PER DWG D3997 REV. B
B159155

Line Total: \$80.00

11	D4732-1P	Label	4/13/2017	6.00	\$13.33	\$80.00
			Yes	Each		
			4/13/2017			

AS PER DWG D4732 REV. B
B159157

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Line Total: \$80.00

12	D5055-5P	Placard	4/13/2017	FN 6.00	\$13.33	\$80.00
			Yes	Each		
			4/13/2017			

AS PER DWG D5055 REV. A
B159158

Note:

4/5/2017

210 Main West
Hawkesbury, Ontario K6A 2H6
Canada

INVOICE

Invoice No.: 44069
Date: 04/11/2017
Ship Date:
Page: 1
Re: Order No.

Sold to:

Dart Aerospace Ltd

1270 Aberdeen
Hawkesbury, Ontario
K6A 1K7

Ship to:

Dart Aerospace Ltd

1270 Aberdeen
Hawkesbury, Ontario
K6A 1K7

Quantity	Description	Base Price	Disc. %	Unit Price	Amount
6	D3997-9P.	13.33		13.33	79.98
6	D3997-13P.	13.33		13.33	79.98
6	D3997-15P.	13.33		13.33	79.98
6	D3997-21P.	13.33		13.33	79.98
6	D3997-23P.	13.33		13.33	79.98
6	D3997-31P.	13.33		13.33	79.98
6	D3997-33P.	13.33		13.33	79.98
6	D3997-37P.	13.33		13.33	79.98
6	D3997-41P.	13.33		13.33	79.98
6	D4732-1P.	13.33		13.33	79.98
6	D5055-5P.	13.33		13.33	79.98
6	D5055-7P.	13.33		13.33	79.98
6	D5055-9P.	13.33		13.33	79.98
	Attn: Chantal PO#35850				
	Subtotal:				1,039.74
	H - HST				
	HST				135.20

SP17 4-17

DAS
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3c

Thank you for your business / Merci de faire affaire avec nous

Shipped By:	Tracking Number:	HST: 825007651RT0001	Total Amount	1,174.94
Comment: WO20005			Amount Paid	0.00
Sold By:			Amount Owing	1,174.94

******CERTIFICATE of CONFORMITY******

Customer:

Studio SL2

Purchase Order N°:

35850

Packing Slip N°:

wo# 20005

Part N°:

Serial N°:

Description:

D3997-9P, 13P, 15P, 21P, 23P, 31P, 33P, 37P,
41P, D4732-1P, D5055-5P, 7P, 9P.

Quantity:

78

Certification:

We hereby certify that:

1. The above listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

Avery

APPROVAL: Valerie Young

Signature:

Val Y

Title: office administrator

DATE:

April 11.17.

PRODUCT DATA SHEET



Avery® IPM I™ 7112

issued: 15/04/2002

Introduction

Avery IPM I 7112 is a white monomeric calendered removable self-adhesive vinyl for use on the Idanit 162Ad inkjet printer, providing good machine runnability. Because of its cost efficiency and good removability, Avery IPM I 7112 is recommended for a wide range of short term applications on flat substrates requiring easy and clean removal.

Description

Film : 100 micron gloss white monomeric calendered vinyl
Adhesive : **removable**, acrylic based
Backingpaper : kraft paper, 140 g/m²

Conversion

Avery IPM I 7112 is specially developed for use on the Idanit 162Ad and Idanit Novo inkjet printer and has been officially approved by Idanit using BL and Magic inks.

Uses

- Interior & exterior signs.
- Window decoration.
- Temporary promotional and point of sale advertising and all.
- applications to flat or regular surfaces that require removability.

Features

- Good printability and handling on Idanit 162Ad.
- Easy conversion.
- Most economical solution for short term outdoor graphics.
- Easy and clean removal (up to 1 year).



Graphics Division
Rijndijk 86, P.O. Box 118
2394 ZG Hazerswoude – The Netherlands
Tel: +31 71 3421500 – Fax: +31 71 3421508

PRODUCT CHARACTERISTICS

Avery® IPM I™ 7112

Physical properties

Features	Test method ¹	Results
Caliper, facefilm	ISO 534	100 micron
Opacity	ISO 2471	92%
Dimensional stability	DIN 30646	0.3 mm max.
Adhesion, initial	FINAT FTM-1, stainless steel	225 N/m
Adhesion, ultimate	FINAT FTM-1, stainless steel	400 N/m
Flammability		Self extinguishing
Shelf life	Stored at 22° C/50-55 % RH	2 years
Removability		up to 1 year*
*Not when applied to: Nitrocellulose paints, ABS, Polystyrene, screenprinting inks (fresh), certain types of PVC		
Durability, unprinted	Vertical exposure	2 years

Temperature range

Features	Results
Minimum application temperature:	≥ 0° C
Temperature range:	- 40 to +100 °C

Important

Information on physical and chemical characteristics is based upon tests we believe to be reliable. The values listed herein are typical values and are not for use in specifications. They are intended only as a source of information and are given without guarantee and do not constitute a warranty. Purchasers should independently determine, prior to use, the suitability of this material to their specific use. All technical data are subject to change.

Warranty

Avery® branded materials are manufactured under careful quality control and are warranted to be free from defect in material and workmanship. Any material shown to our satisfaction to be defective at the time of sale will be replaced without charge. Our aggregate liability to the purchaser shall in no circumstances exceed the cost of the defective materials supplied. No salesman, representative or agent is authorised to give any guarantee, warranty, or make any representation contrary to the foregoing. All Avery® branded materials are sold subject to the above conditions, being part of our standard conditions of sale, a copy of which is available on request.

1) Test methods

More information about our test methods can be found on our website.

2) Durability

The durability is based on middle European exposure conditions. Actual performance life will depend on substrate preparation, exposure conditions and maintenance of the marking. For instance, in the case of signs facing south; in areas of long high temperature exposure such as southern European countries; in industrially polluted areas or high altitudes, exterior performance will be decreased.



www.averygraphics.com

Graphics Division

Rijndijk 86, PO Box 118
2394 ZG Hazerswoude – The Netherlands
Tel: +31 71 3421500 – Fax: +31 71 3421508